

Date: Tuesday, 11/11/2008 10:18:12 AM  
 User: Jean-Luc Menard

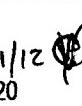
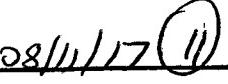
## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE		
Job Number	: 43303					
Estimate Number	: 12773					
P.O. Number	:		Part Number	: 41232 200 002 001		
This Issue	11/11/2008	S.O. No. :	Drawing Number	: 41232-200-002 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	: A		
Previous Run	: 42265		Material	:		
Written By	<u>J.L.M. 08.11.11</u>		Due Date	18/11/2008	Qty:	12 Urm: Each
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-03-05 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3H1375	2024-T3 Hex Bar 1.375"
		
Comment: Qty.: 0.4550 f(s)/Unit Total : 5.4596 f(s)		Not removed from computer 08/11/12
2024-T3 Hex Bar 1.375"		
Batch: M106680 08/11/12 		12 pcs
2.0	LATHE CONV.	CONVENTIONAL LATHE
		
Comment: CONVENTIONAL LATHE		
Turn as per Dwg 41232-200-0021		08/11/12 
TURN BORE TAP DRILL 45/64" AND TAP 3/4"20		12 pcs
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA687 Rev: <u>A</u> & Dwg 41232-200-002 Rev: <u>A</u>		
2-Deburr		J.F. 08/11/17 
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.F. 08/11/17 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 41232-200-002-001 PAR #: N/A Fault Category: Prod - Macro NCR: Yes No DQA: 11 Date: 08.11.27  
 (41232-200-001-001/-002) Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 08/11/28

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/17	4.0	120° Hole is Drill thru Hole is suppose to be just on one side.	J.F. 08/11/17	Scrap and Destroy no Replace Qty X	J.F. 08/11/17	✓ 08/11/17	J 08/11/17	S 08/11/17
		R.C operator placed part on wrong orientation- Labeled ATTENTION						

NOTE: Date & initial all entries

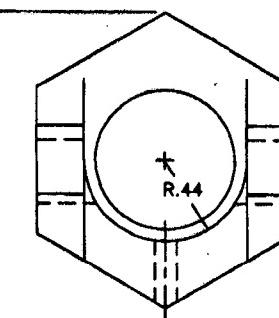
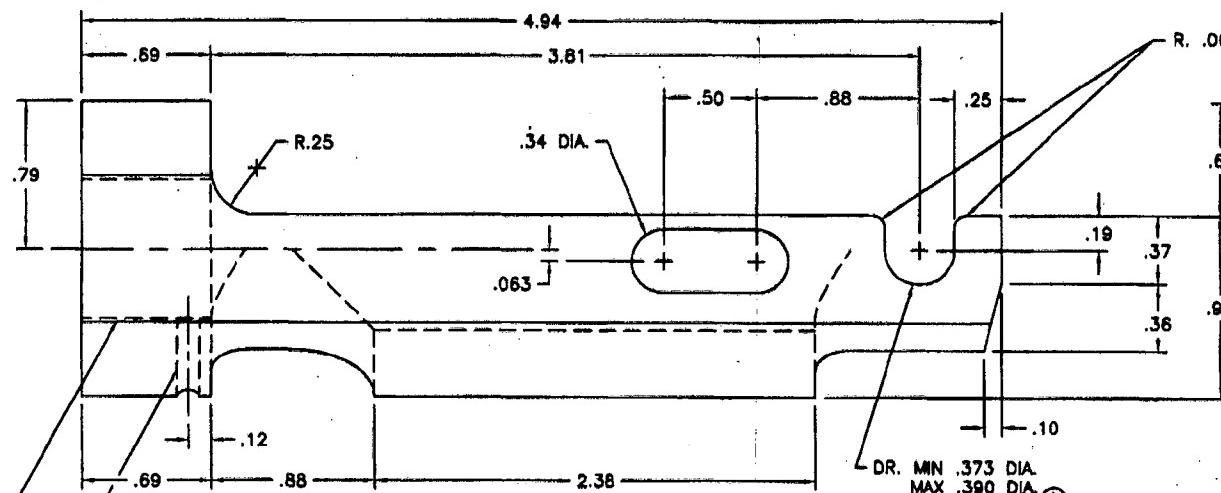
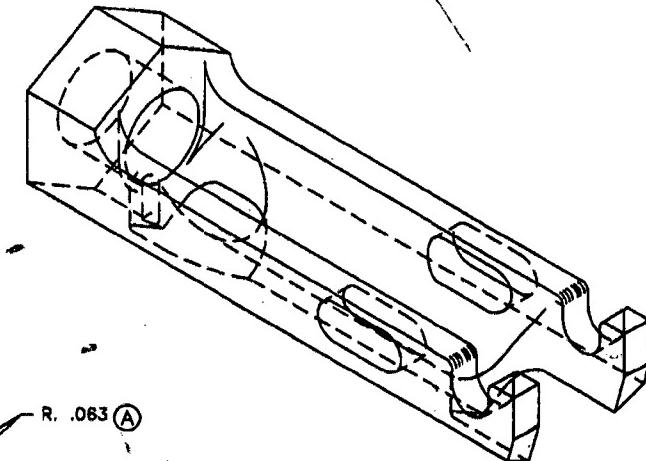
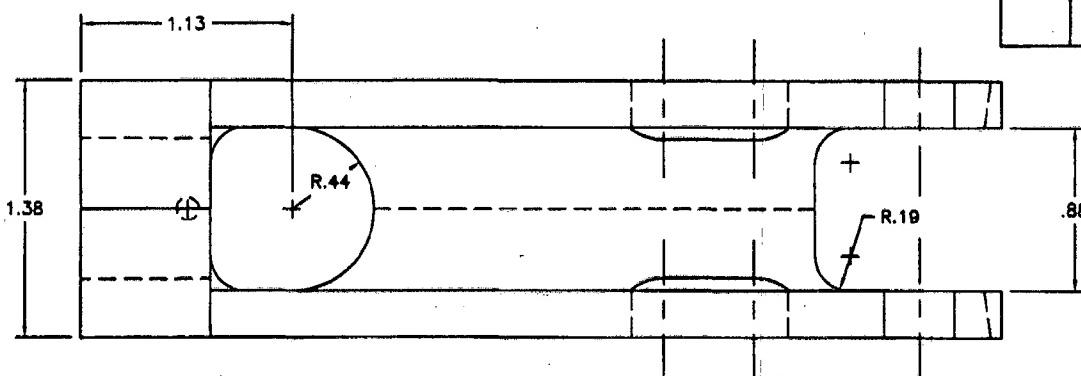
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: TUBE
Job Number: 43303		Part Number: 41232 200 002 001
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		88 08/11/17
7.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH 
Comment: Sub-Contracting PURCHASING Issue P/O: 76013 Black Anodize as per Dwg 41232-200-005 Ensure Certificate of Conformity is attached		CLO8/11/18 11
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached		LC 8/11/26 11
9.0	QC3	INSPECT POWDER COAT/ CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION		Sgaluas 10
10.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 364 364		8/11/26 11
11.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/11/27 11
Job Completion 		MF 08-11-28

## REVISION

LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001. MINOR CHANGE - FAR 21.95 CHECK \ D. MURPHY 2/17/03		



W/0 43303

-001 TUBE

NO. REQ'D PER ASSY	PART NO.	NAME	LIST OF MATERIAL			
			STOCK SIZE	MATERIAL	MATL.SPEC	ZONE
1	MS21209F4-15	INSERT				
	-005	PIVOT ARM A	1.00 DIA. x 3.56	2024-T4, T351 ALUM.		
	-003	LATCH A	1.11 x 3.50	2024-T4, T351 ALUM.		
	-001	TUBE A	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.		
	-005	PART NO.				

PROPRIETARY  
RIGHTS NOTICE  
THIS DRAWING IS  
PROPRIETARY TO  
EMERSON INC.  
EXCLUSIVELY FOR  
MANUFACTURE AND  
DISPOSITION, ON USE OF  
THESE DRAWINGS FOR ANY  
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THE FOREGOING, WITHOUT  
AUTHORIZATION FROM  
EMERSON INC., IS  
UNLAWFUL.  
THE FOREGOING DOES  
NOT APPLY TO  
VENDOR PARTS.

EMERSON INC.  
2 41232-200-001

NEXT ASSEMBLY

REV.

1

DRFTSMN	D. NELSON	2/18/02	TYPE	STEP ACTUATOR
CHECK	D. MURPHY	2/18/02	COMPONENTS	
STRESS				
PROJ.				
ENG.R.			DRAW. SIZE	C
HEAT TREAT			SCALE	2:1
FINISH			DWG. NO.	41232-200-002
			SHT 1 OF 3	A

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2  
DYED BLACK.

NOTE:

DART AEROSPACE LTD	Work Order:	43303
Description: <i>Tube</i>	Part Number:	41232-200-002-00
Inspection Dwg: <i>41232-200-002</i>	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.690	$\pm 0.030$	.693				
4.94	$\pm 0.030$	4.945				
3/4 - 20		3/4 - 20				
.44 Radii	$\pm 0.030$	.439				
.610	$\pm 0.030$	.609	✓			
.88	$\pm .030$	.884	✓			
.063	$\pm .010$	.063	✓			
1.38	$\pm .030$	1.375	✓			
.69	$\pm .030$	.690	✓			
.12	$\pm .030$	.126	✓			
$\phi .12$		.126				
.980	$\pm .030$	.971	✓			
.25	$\pm .030$	.257	✓			
.36	$\pm .030$	.349	✓			
.370	$\pm .030$	.374	✓			
.10	$\pm .030$	.100	✓			
R.063	$\pm .010$	R.063	✓			
.373	$\pm .017$	.374	✓			
$\phi .34$	$\pm .030$	$\phi .339$	✓			
R.25	$\pm .030$	R.250	✓			
2.38	$\pm .030$	2.384	✓			
3.81	$\pm .030$	3.808	✓			

08/11/12

Measured by:	J.F.	Audited by:	J.L.	Prototype Approval:	
Date:	08/11/12	Date:	08/11/12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**TNM ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certifié

Certifié NADCAP certified

PACKING

SLIP

70407

25-Nov-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**NO. DE COMMANDE:****PURCHASE ORDER/****214699/7613**

ITEM	COMMANDE ORDERED	EXPEDITED SHIPPED	PART NUMBER & DESCRIPTION	REMARKS
1	11	11	41232-200-002-001	B43303

**PICKED UP BY / REÇU:** \_\_\_\_\_*En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.**Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.*

TNM

# *ANODISATION et PEINTURE TNM INC.*



*21 chemin de l'Aviation, Pointe-Clair QC H9R 4Z2*

**Telephone: (514) 429-7777 Fax: (514) 429-5108**

Certifié ISO 9001-2000 certified

Certifié NADCAP certif. id.

**FACTURE  
INVOICE**

**70407** Rev.00

25-Nov-2008

**CLIENT / CUSTOMER:**

DART AEROSPACE LTD.

1270 ABERDEEN STREET

## HAWKESBURY      ONTARIO

K6A 1K7

**NO. DE COMMANDE: 214699/7613**  
**PUI CHASE ORDER/**

#### **CONDITIONS / TERMS:**

NET 30 JOURS / NET 30 DAYS

#### *CO/DITIONS / TERMS*

NE1 30 JOURS / NET 3

*No de TPS / GST # : 891559734 RT  
No de TVQ / OST # : 1019307154 TO000*

**CERTIFICAT DE CONFIRMATION Émis pour chaque procédure**  
**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

*En cas de perte ou de dommages dû à la valeur intrinsèque de certaines responsabilités se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.*

*Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.*

**TNM****ANODISATION et PEINTURE TNM INC.****C. OF C**

**21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2**  
**Telephone: (514) 429-7777 Fax (514) 429-5108**  
**Certifié ISO 9001-2000 certified**  
**approuvé NADCAP approved**

**70407**

25-Nov-2008

**CLIENT / CUSTOMER:**

**DART AEROSPACE LTD.**  
**1270 ABERDEEN STREET**  
**HAWKESBURY, ONTARIO**  
**K6A 1K7**

**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITÉ**

**NO. DE COMMANDE: 2 4699/7613**  
**PURCHASE ORDER/**



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER	DESCRIPTION	MANUFACTURER'S APPROVAL
1	11	11	41232-200-002-001	B43303	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2

S  
esteban

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

48

**Signature/Signed:****Directeur de la Qualité / Q.A. Manager**